



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

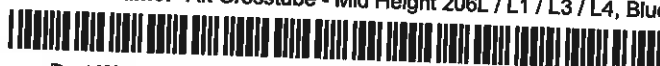
D206-667-207BL
Job Sheet 200062



Part No: D206-667-207BL

Job Qty: 1 pcs

Part Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Created By: Marie Lajeunesse

Description: ORDER 19294

Due Date: 10/3/19

Type: SOLD

Note: DWG D206-667-207 REV.B / IPP RevA 11.01.13 New Issue EC verified by:DD IPP REV:B 11.08.08 PER ECN 11-615 DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Crosstubes - Bend - 1	1 pcs	10/3/19	10/3/19	0.50	4.35	Crosstubes - Bend	DB 9/17/2019
120	QC 15	1 pcs	10/3/19	10/3/19	0.00	0.00	QC 15 - 12	
							QC 15 - 3	
							QC 15 - 47	
							QC 15 - 49	
							QC 15 - 58	
							QC 15 - 9	DAS SEP 17 2019 68
							QC 15 - 68	
130	Crosstubes - 2 - B4B	1 pcs	10/3/19	10/3/19	0.00	2.86	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
140	Crosstubes - 3 - B4B	1 pcs	10/3/19	10/3/19	0.00	0.55	Crosstubes - 1 - B4B	DB 9/19/2019
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
150	QC 7	1 pcs	10/3/19	10/3/19	0.00	0.00	QC 7 - 10	
							QC 7 - 13	
							QC 7 - 14	
							QC 7 - 15	
							QC 7 - 17	
							QC 7 - 18	
							QC 7 - 19	
							QC 7 - 2	
							QC 7 - 28	
							QC 7 - 3	
							QC 7 - 30	
							QC 7 - 34	
							QC 7 - 36	
							QC 7 - 37	

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					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	GP 19-09-19.
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160 QC 5	1 pcs	10/3/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	DA
					QC 5 - 30	48
					QC 5 - 40	SEP 19 2019 9-48
					QC 5 - 61	
					QC 5 - 81	
170 Outsource - 2 - NDT per QSI038	1 pcs	10/3/19			SKY002-VC	1 PL 09/20/2019
180 Packaging 2-1 - Receive - B4B	1 pcs	10/3/19	0.00 0.00		Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Plex 9/6/19 10:39 AM Dart.lajeunesse.marie	

					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
190 QC 5	1 pcs	10/3/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
195 Spray Paint - 2 - B4B	1 pcs	10/3/19	0.00 2.26		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
198 QC 14	1 pcs	10/3/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
220 Crosstubes - 4 - B4B	1 pcs	10/3/19	0.00 2.86		Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
230 Crosstubes - 5 - B4B	1 pcs	10/3/19	0.00 1.91		Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	

DAS

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9-89

SEP 23 2019

19-9-21

DAS

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SEP 24 2019

19-9-22

240 QC 5	1 pcs	10/3/19	0.00 0.00	Crosstubes - 4 - B4B	• AR 19-9-22
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	SEP 25 2019
				QC 5 - 61	
				QC 5 - 81	
250 Packaging 1-2 - Pick Kit - B4B	1 pcs ✓	10/3/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B ✓	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	10/3/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	

Wed 9-25-2019
Rosales, Oscar
(012100)

SEP 25 2019
DAS
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9-89

9/25/2019
Mays

270 Packaging 3-1 - Stock - B4B	1 pcs	10/3/19	0.00 0.00	QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	10/3/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	1 pcs	10/3/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 110 - CNC Alpha 160 Bender - Bend tube as per Dwg D206-667-247 using CNC bender program D206-667-207

Descriptions: 120 - QC15- Crosstube Dimensional Check

130 - Crosstubes ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED

BY: ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-247 ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: *****

2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-247. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D206-667-247. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill only the top (2) holes. Drill & ream the top (2) hole

140 - Crosstubes Chemical Conversion ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

150 - QC7-Inspect Chemical Conversion Coat

160 - QC5- Inspect part completeness to step on W/O

- 170** - Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order
- 180** - Receive & Inspect for Damage & Mat'l Certs *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.
- 190** - QC5- Inspect part completeness to step on W/O *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure results are as per Dwg D206-667-247
- 195** - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____ **MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: 5:17:33 Finish Time: _____ PAINT: DELFLEET BLUE 5187836 Start Time: _____ Finish Time: _____ CLEAR DELFLEET B 5173359
- 198** - QC14- Inspect Spray Paint Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____
- 220** - Crosstubes - 1-Install nut plates as per Dwg D206-667-247.
- 230** - 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: 5176610 exp 10/19 3- Torque bolts as per dwg
- 240** - QC5- Inspect part completeness to step on W/O ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____
- 250** - Pick Kit
- 260** - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____
- 270** - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-667-207 Location: _____ PPP Rev: _____
- 275** - Document Control Photocopy bluefile and create labels as per PPP D206-667-207 chg 002
- 280** - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-667-247TRN	Crosstube Assembly, Mid Aft	1 pcs (1 ea)	110-Crosstubes - Bend - 1	5012466
D2873-043	Nut Plate Assembly	2 pcs (2 ea)	220-Crosstubes - 4 - B4B	
D2873-045	Nut Plate Assembly	2 pcs (2 ea)	220-Crosstubes - 4 - B4B	
MS20601-AD4W10	Rivet	14 Ea (14 ea)	220-Crosstubes - 4 - B4B	
D2892-1	Support	2 pcs (2 ea)	230-Crosstubes - 5 - B4B	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 pcs (4 ea)	230-Crosstubes - 5 - B4B	
MS21920-22	Clamp	4 Ea (4 ea)	230-Crosstubes - 5 - B4B	
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging 1-2 - Pick Kit - B4B	3200190 ✓
AN5-32A	Bolt	4 Ea (4 ea) ✓	250-Packaging 1-2 - Pick Kit - B4B	5119852 ✓
AN5-34A	Bolt	4 Ea (4 ea) ✓	250-Packaging 1-2 - Pick Kit - B4B	5166955 ✓
MS21042L5	Nut	4 Ea (4 ea) ✓	250-Packaging 1-2 - Pick Kit - B4B	5208332 ✓
NAS1149D0563J	Washer	18 Ea (18 ea) ✓	250-Packaging 1-2 - Pick Kit - B4B	5174288 ✓

(012100) Wed 9-25-2019 Rosales, Oscar

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Crosstubes - Bend - 1	D206-667-247TRN	1	4	0
220-Crosstubes - 4 - B4B	D2873-043 <u>5186472</u>	②	46	0
	D2873-045 <u>5186342</u>	②	28	0
	MS20601-AD4W10 <u>5133678</u>	14 (15) → 1 scrap	39	0
230-Crosstubes - 5 - B4B	D2892-1 <u>5190257</u>	②	12	0
	D3595-063-450 <u>5176511</u>	④ ③ + 1 ?	17 <u>5216945</u>	0
	MS21920-22 <u>5171287</u>	④	55	0
250-Packaging 1-2 - Pick Kit - B4B	AN5-10A	10	138	0
	AN5-32A	④	267	0
	AN5-34A	4	33	0
	MS21042L5	4	373	0
	NAS1149D0563J	18	1,429	0

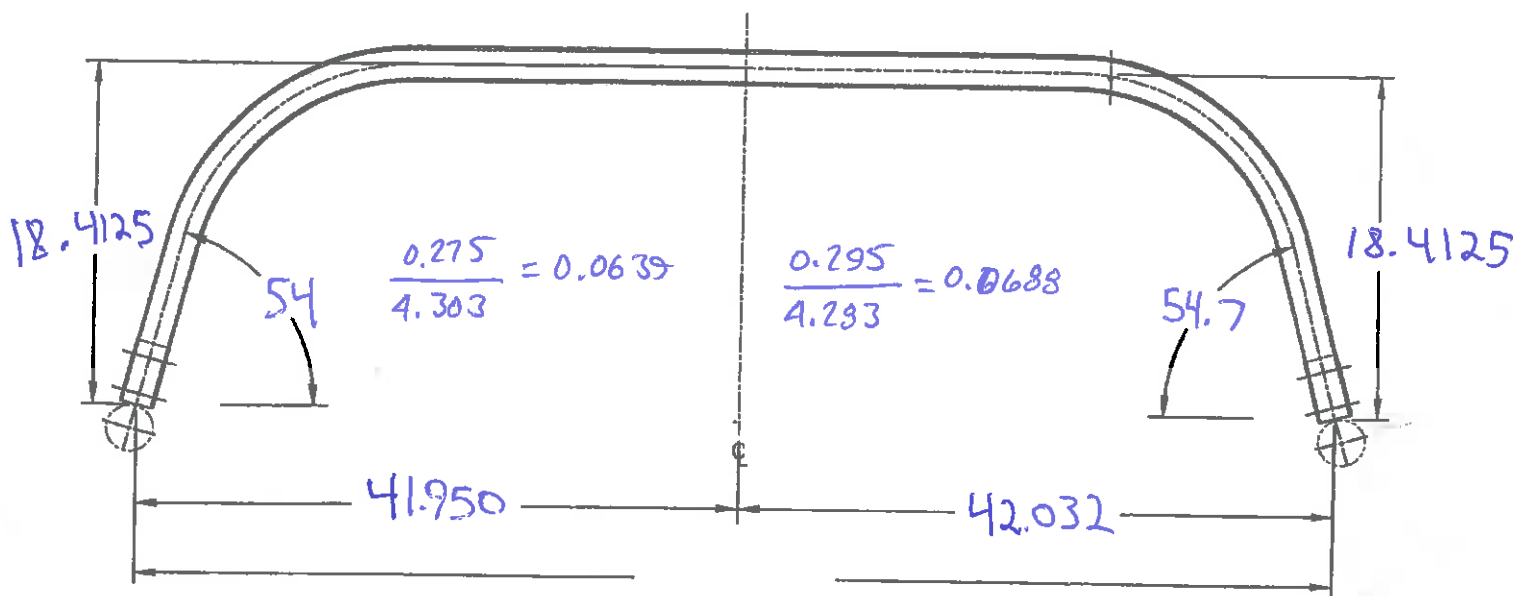
Part Specifications

Specifications could not be found.

Plex 9/6/19 10:39 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	200062
Description: Crosstube Mid Aft (206L)		Part Number:	D206-667-207
Inspection Dwg: D206-667-247	Rev: B	Page 1 of 1	

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes		
Crushing	6.4%	6.9%
Comments		
Acceptable crushing per DR-1059 Rev A 9/19/17		

2014
2.289

1.994
2.289

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	
C	19.05.23	New revision of drawing	MG	

Item	Qty	Part Number	Description
1	X	D206-687-247	CROSSTUBE ASSEMBLY (208L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-083-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20801AD4W10	RIVET (OR NAS8302B-4-10)
9	AR	PROSEAL 880 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 98.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 006 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER D206-687-247 AND BATCH NUMBER ON INSIDE OF CLIP PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 ± 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY.
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 880 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-083-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.006" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMP8 AFTER PROSEAL 880 SEALANT HAS CURED FOR 72 HOURS.

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OFFICE
30 SEP 1977

200062 MJS
19-09-06

B	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER DART 18-241. UPGRADE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DED A-1.	JMH	18.05.01
A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN		JMH	
DRAWN		JMH	
CHECKED		ZF	
MFG. APPR.		ZF	
APPROVED		JMH	
DATE			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D206-687-247
TITLE	CROSSTUBE ASSY (208L MID AFT)
SCALE	NTS
REV. B	SHEET 1 OF 4
DATE	18.05.01

RELEASED
2018 SEP 06
ECN 18-777

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition					
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044535



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044535
PO Date: 9/19/19
Due Date: 9/20/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196105	D206-667-103	Fwd Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	9/20/19	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
2	196106	D206-667-103	Fwd Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	9/20/19	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044535



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	200061	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC- 32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed XI	-	9/20/19	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
4	200062	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC- 32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed XI	-	9/20/19	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
5	199238	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed XI	-	9/20/19	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50

DAG
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2-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044535



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	99239	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed X	-	9/20/19 SEP 20 2019	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
Grand Total:											\$915.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/20/19 2:05 PM dart.lussier.patrick

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO41837	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044535
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

2 FWD CROSSTUBES , P/N: D212-664-101 , J/S: 199238 , 199239

2 AFT CROSSTUBES , P/N: D206-667-207BL , J/S: 200061 , 200062

2 FWD CROSSTUBES , P/N: D206-667-103 , J/S: 196105 , 196106

DAS
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9-89

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						SEP 20 2019	m DOT-APP 20 53-89
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

RECEIVED
SEP 20 2019
DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp DOT-APP 20 53-89	Date: SEP 20 2019
Name: RAFIK MELIKIAN		

SKYM002-1 REV 5 Apr/17

5.2 MID-HEIGHT CROSSTUBES

Item	Qty -107	Qty -207	Part Number	Description
	X		D206-667-107	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID FWD
		X	D206-667-207	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID AFT
7	1		D206-667-147	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID FWD
8			D206-667-247	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID AFT
10	*2		D2891-1	SUPPORT
11		*2	D2892-1	SUPPORT
13	*4		D3595-063-395	RUBBER CUSHION
14		*4	D3595-063-450	RUBBER CUSHION
16	*4		MS21920-20	CLAMP
17		*4	MS21920-22	CLAMP
19	4		AN5-32A	BOLT
20			AN5-34A	BOLT
21	4		MS21042-5	NUT (OR MS21042-5)
22	8		NAS1149CJD516	WASHER (OR AN950JD516)
40	*2	*2	D2873-043	NUT PLATE
41	*2	*2	D2873-045	NUT PLATE
44	10		AN5-7A	BOLT
45			AN5-12A	BOLT
46	4		AN5-30A	BOLT
47			AN5-32A	BOLT
48	12		AN970-4	WASHER (OPTIONAL)
50	10		NAS1149CJD516	WASHER (OR AN960JD516)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-147/-247 ASSEMBLIES ABOVE

Change Record

PAGE 1 OF 1

Part Number: D206-667-207/-207BL

Description: CROSSTUBE INSTALLATION, 206L/L1/L3/L4 MID AFT

[illegible]